



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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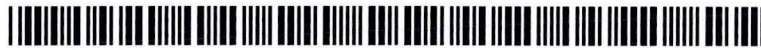
RBW6305G01232-3G
Job Sheet 186958



Part No: RBW6305G01232-3G

Job Qty: 1 pcs

Part Name: Gimbal Torque Tube Bushing Remover



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G01232-3G Rev 3 IPP Rev A 18.02.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	12/14/18		0.00	0.08	External Load - 1		AP 2019/03/06
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	12/14/18		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	12/14/18		0.00	0.00	Packaging 3 - 1 - B4B		MAR 0 8 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



Container No: S159498



Part: RBW6305G01232-3G

Job No: 186958

Serial No/Batch: S159498

Revision: 3

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/06/19

Plex 3/5/19 4:01 PM Dart.Hadley.Shannon

GA 098

Part Op **100** - Small Fab-9 (Small Fab) 1-Assemble as per DWG Loctite 262 B _____ Exp
 Descriptions: **110** - QC5 (QC5- Inspect part completeness to step on W/O)
130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and Stock
140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN315-6R	3/8"-24 RH Threaded Nut	1 Ea (1 ea)	100-Small Fab - 1	
NAS1149F0632P	Washer	1 Ea (1 ea)	100-Small Fab - 1	
RBW6305G01232-3G-1	Receiver	1 pcs (1 ea)	100-Small Fab - 1	
RBW6305G01232-3G-3	Stud	1 pcs (1 ea)	100-Small Fab - 1	
RBW6305G01232-3G-5	Spacer	1 pcs (1 ea)	100-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN315-6R	1	274	0
	NAS1149F0632P	1	403	0
	RBW6305G01232-3G-1	1	12	0
	RBW6305G01232-3G-3	1	12	0
	RBW6305G01232-3G-5	1	4	0

Part Specifications

Specifications could not be found.



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Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G01232-3G Rev 3 IPP Rev A 18.02.21 New issue DP Verify DD

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Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	12/14/18		0.00	0.08	Small Fab - 1		
							Small Fab - 2		Michel
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	12/14/18		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
120	QC	1 pcs	12/14/18		0.00	0.00			
130	Packaging 3-1 - Stock - B4B	1 pcs	12/14/18		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	12/14/18	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
Part Op 100 - Small Fab-9 (Small Fab) 1-Assemble as per DWG Loctite 263 5048298 Exp. 04/20 Descriptions: 110 - QC5 (QC5- Inspect part completeness to step on W/O) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and Stock 140 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
ST33 AN315-6R	3/8"-24 RH Threaded Nut	1 Ea (1 ea)	100-Small Fab - 1	5048298	
ST262 NAS1149F0632P	Washer	1 Ea (1 ea)	100-Small Fab - 1	5048297	
GA96 RBW6305G01232-3G-1 -90	Receiver x4	1 pcs (1 ea)	100-Small Fab - 1	5082536	
RBW6305G01232-3G-3	Stud	1 pcs (1 ea)	100-Small Fab - 1	5090514	
RBW6305G01232-3G-5 -90	Spacer	1 Ea (1 ea)	100-Small Fab - 1	5081108	
LOCTITE					
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Small Fab - 1	AN315-6R	1	274	0	
	NAS1149F0632P	1	427	0	
	RBW6305G01232-3G-1	1	12	0	
	RBW6305G01232-3G-3	1	12	0	
	RBW6305G01232-3G-5	1	4	0	
Part Specifications					
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Status: New

Priority: Medium

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Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G01232-3G Rev 3 IPP Rev A 18.02.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	1 pcs		12/14/18	0.00	0.08	Small Fab-9		
110	QC	1 pcs		12/14/18	0.00	0.00	QC5		
120	QC	1 pcs		12/14/18	0.00	0.00			
130	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-2		
140	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21		

Part Op 100 - 1-Assemble as per DWG Loctite 262 B _____ Exp. _____
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN315-6R	3/8"-24 RH Threaded Nut	1 Ea (1 ea)	90-Start up Operation	
AN960-616L	5/8" OD, THIN FLAT WASHER see NAS1149F0632P	1 Ea (1 ea)	90-Start up Operation	
RBW6305G01232-3G-1	Receiver	1 Ea (1 ea)	90-Start up Operation	
RBW6305G01232-3G-3	Stud	1 Ea (1 ea)	90-Start up Operation	
RBW6305G01232-3G-5	Spacer	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN315-6R	1	276	0
	AN960-616L	1	0	0
	RBW6305G01232-3G-1	1	12	0
	RBW6305G01232-3G-3	1	12	0
	RBW6305G01232-3G-5 - PO	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

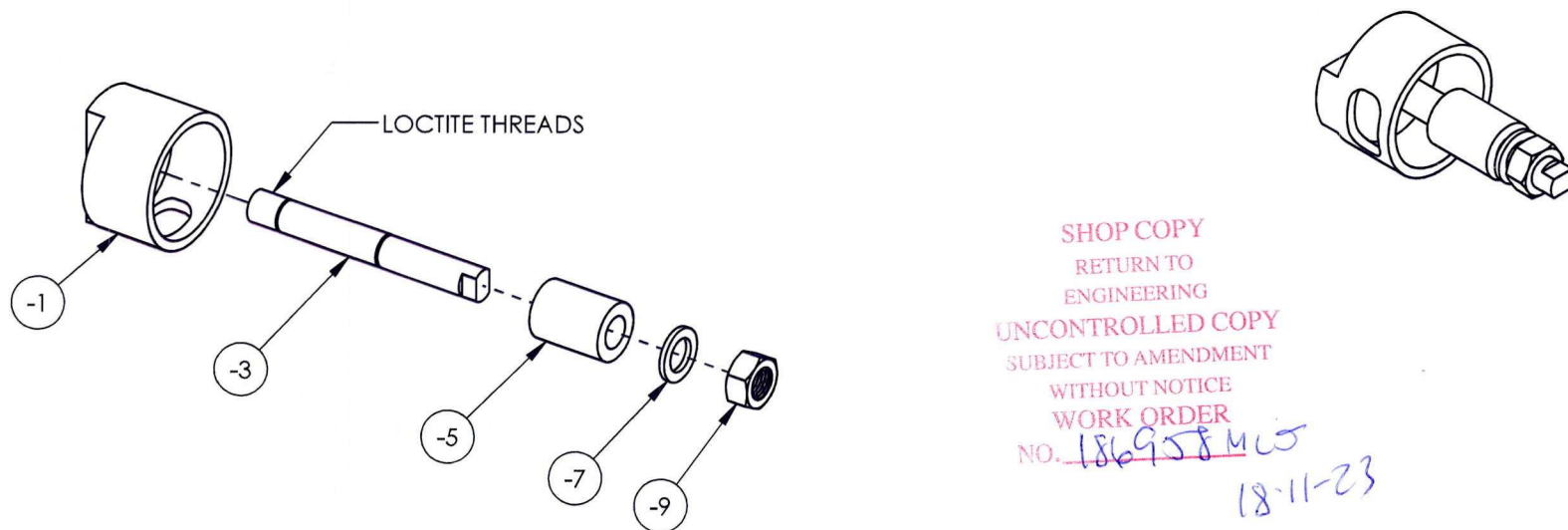
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		BROKE OUT INTO INDIVIDUAL TOOLS FROM KIT RBW6305G00132-3G.	4/7/2011	RJC	
1		-3 CH'D DIM WAS $\varnothing.375$ IS $.370 +.000 -.005$, ADDED THREAD NOTE $\varnothing.370-.367$. -5 CH'D DIM WAS $\varnothing.381$ IS $\varnothing.375 +.005-.000$.	5/10/2013	CFS	GE
2		-3 CH'D MATERIAL WAS 4140 Q&T IS 4140/4142.	5/6/2014	LA	RJC
3	15-0321	-1 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -3 DELETED DIMS $\varnothing.370 +.000-.005$ AND $\varnothing.370-.367$. -5 CH'D MATERIAL CALLOUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T.	10/2/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186958 MLC

18-11-23

NOTES:

1. REF. AGUSTA T/N: 3G6305G01232.
2. PART OF KIT RBW6305G00132-3G.

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING REMOVER	
DWG NO. RBW6305G01232-3G	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weik</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:2	DATE 4/7/2011
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	4140 Q&T / 4142 Q&T		2
			-3	1	STUD	4140/4142	$\varnothing 3/8$ X 3-1/8 (MCMaster-CARR #8935K336) MODIFIED	3
			-5	1	SPACER	4140 Q&T / 4142 Q&T		4
		B/O	-7	1	WASHER	STEEL	$\varnothing 3/8$ AN960-616L	1
		B/O	-9	1	HEX NUT	STEEL	3/8-24 UNF -2B AN315-6	1
		B/O	-11	1	LOCTITE 262		AS REQUIRED	N/S